

Work Order ID 63784



Page 1

Monday, November 15, 2010 8:28:57 AM

Item ID: D206-559-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 11/12/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/11/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9527	rev A
IIN-D206-559	rev K

100 0.00



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPPID206-559-011 CHG007

*for BG 10-12-8**10/12/08*

160



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

10/12/08 SF (u)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63784

Page 2

Monday, November 15, 2010 8:28:57 AM

Item ID: D206-559-011

Accept



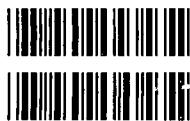
Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 11/12/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC4- 100% Inspect kits for completeness

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

801208

(X)

180



Packaging

Packaging

0.00

Revc

0.00

10/15/8 (4)

Packaging

Identify and pack for shipping as per PPPD206-559-011

Memo

Location: //

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/14 (1)

MF

10-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, November 15, 2010 8:29:01 AM

Work Order ID: 63784



Parent Item: D206-559-011



Parent Item Name: Bearpaw

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:C 04.02.17L Blank size changed□KJ/JLM□
IPP Rev:D 07-01-02 Was K10007 JLM
IPP Rev:E 08-05-05 up a chg DD verified by:EC
IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified
By:EC IPP Rev G 10.10.04 per DS19527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A S 44 Bolt		Purchased	No			160	Each	410.0000	8	32		10/12/88	

Location	Loc Qty	Loc Code
ST359	410	
112314	410	

AN4-20A G A Bolt	Purchased	No		160	Each	466.0000	8	32		10/12/88		
------------------------	-----------	----	--	-----	------	----------	---	----	--	----------	--	--

Location	Loc Qty	Loc Code
ST359	466	
104016	266	
115936	200	

AN960JD416 Washer	NAS1149D0463J	Purchased	No		160	Each	24.0000	16	64		1116289 10/12/88 SP40	
----------------------	---------------	-----------	----	--	-----	------	---------	----	----	--	-----------------------	--

Location	Loc Qty	Loc Code
ST300	24	
113288	24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:29:01 AM

Page 2

Work Order ID: 63784



Parent Item: D206-559-011



Parent Item Name: Bearpaw

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 4.00

Required Qty: 4.00

D2182B



Rubber Cushion

Manufactured No

160

f

393.2859

1.666

6.664



10/12/85

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST410	393.28594	
52649	43.28594	
63413	350	✓

(D2182B050) Cut (4) at 5.00" as per dwg ***per
kit***

D2274



Radius Block

Manufactured No

160

Each

397.0000

8

32



B63990 10/12/85

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST010	397	
59108	4	
61361	78	
62658	315	

D2435*



Bearpaw, 206

D2438



Clamp

Manufactured No

160

Each

0.0000

2

8



63288 ✓

Manufactured No

160

Each

179.0000

4

16



10/12/85 ✓

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST456	179	
60852	179	✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:29:02 AM

Page 3

Work Order ID: 63784



Parent Item: D206-559-011



Parent Item Name: Bearpaw

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 4.00

Required Qty: 4.00

D2529



Manufactured

No

160

Each

481.0000

8

32



Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST017	481	
-------	-----	--

61979	481	
-------	-----	--

MS21042L4



Purchased

No

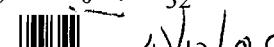
160

Each

2,556.000

8

32



Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	2556	
-------	------	--

113422	25	
--------	----	--

114523	8	
--------	---	--

115589	1423	
--------	------	--

115621	1100	
--------	------	--

QS200-M44S



Purchased

No

160

Each

40.0000

2

8

Clamp

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST450	40	
-------	----	--

115410	20	
--------	----	--

115589	14	
--------	----	--

115621	6	
--------	---	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

**5.0 PARTS LIST (D206-559 REV. K)
32.7 PARTS LIST (ICA-D205-559 REV. 2)**

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
6		6					D2732-050	RUBBER CUSHION
					2		D3456-1	WASHER
					2		D3859-041	WEARPLATE
					2		D3860-041	WEARPLATE
					2		D4010-041	BEARPAW ASSEMBLY
					8		D4011-1	CLAMP, SHORT
					2		D4011-3	CLAMP, LONG
					8		D4011-5	CLAMP, SHORT (OEM)
					10		D4012-1	CUSHION
					2		AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
				4			AN4C13A	BOLT
				8			AN4C15A	BOLT
				8			AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
					20		MS21043-4	NUT
					8		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	D. SHEPHERD (DE # 02)
DATE:	10.06.30
CERT. NO.:	SH92-17
ISSUE NO.:	7

DESIGN	99	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	99		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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